

Work Order ID 63701

November 10, 2010 10:50:33 AM

Page 1

Item ID: D212-725-1-195F

Accept

Setup Start

Revision ID:

Stop

Item Name: Bracket Firewall Ful Shut

Start Date: 11/10/10 Start Qty: 2.00

Cust Item ID:

Required Date: 11/15/10 Req'd Qty: 2.00

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D212-725-1

G

100

0.00



Waterjet

FLOW CNC Waterjet

Memo

0.00

1-Cut as per Dwg

Dwg Rev: G

Prog Rev: G

2-Deburr if necessary

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

B 10-11-11

(2)

EP 10/10/15

B 10-11-11

Work Order ID 63701

November 10, 2010 10:50:33 AM

Page 2

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Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool # Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120

QC8- Inspect parts - second check

0.00

*parts have the
3 Ø2.13 holes in them.
See attached e-mail.*

2

10-11-15

QC

Memo

0.00

Quality Control

121

Chemical Conversion Coat per QSI005 4.1

0.00

2 BR 10-11-16.

HandFinish

Memo

0.00

Hand Finishing

122

QC3- Inspect Part Finish

0.00

*10/11/16**2 Ø*

QC

Memo

0.00

Quality Control

Work Order ID 63701

November 10, 2010 10:50:34 AM



Page 3

Item ID: D212-725-1-195F

Accept



Setup Start



Revision ID:

Item Name: Bracket Firewall Ful Shut

Stop



Start Date: 11/10/10 Start Qty: 2.00



Cust Item ID:

Required Date: 11/15/10 Req'd Qty: 2.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID Tool # Plan
Code Accept Reject Reject Insp.
Qty Qty Number Stamp

130

Identify as per dwg & Stock Location: 394

0.00



Packaging

Memo

0.00

Packaging

FLAT PATTERN ONLY

Accept 12/2

140

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/11/10

mf

10-11-16

Picklist Print

November 10, 2010 10:50:33 AM

Page 1

Work Order ID: 63701

Parent Item: D212-725-1-195F

Parent Item Name: Bracket Firewall Ful Shut

Start Date: 11/10/10

Required Date: 11/15/10

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP rev A 10.07.21 new issue EC verified by:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M2024T3S.025		Purchased	No			100	sf	48.0000	0.13	0.273684			



ALUM SHEET .025



B 10-11-11

Location

Loc Qty

Loc Code

MAT

48

116076

48

103504

103504

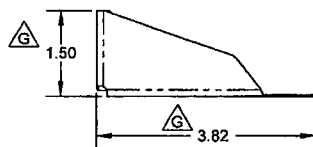
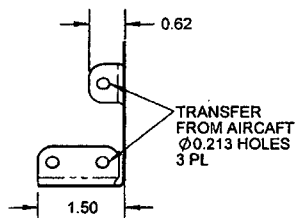
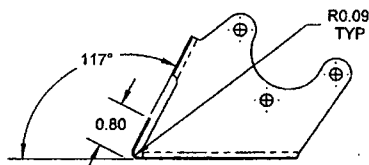
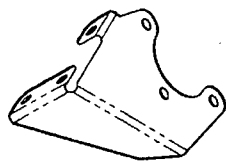
②

DDID-705-1-195F

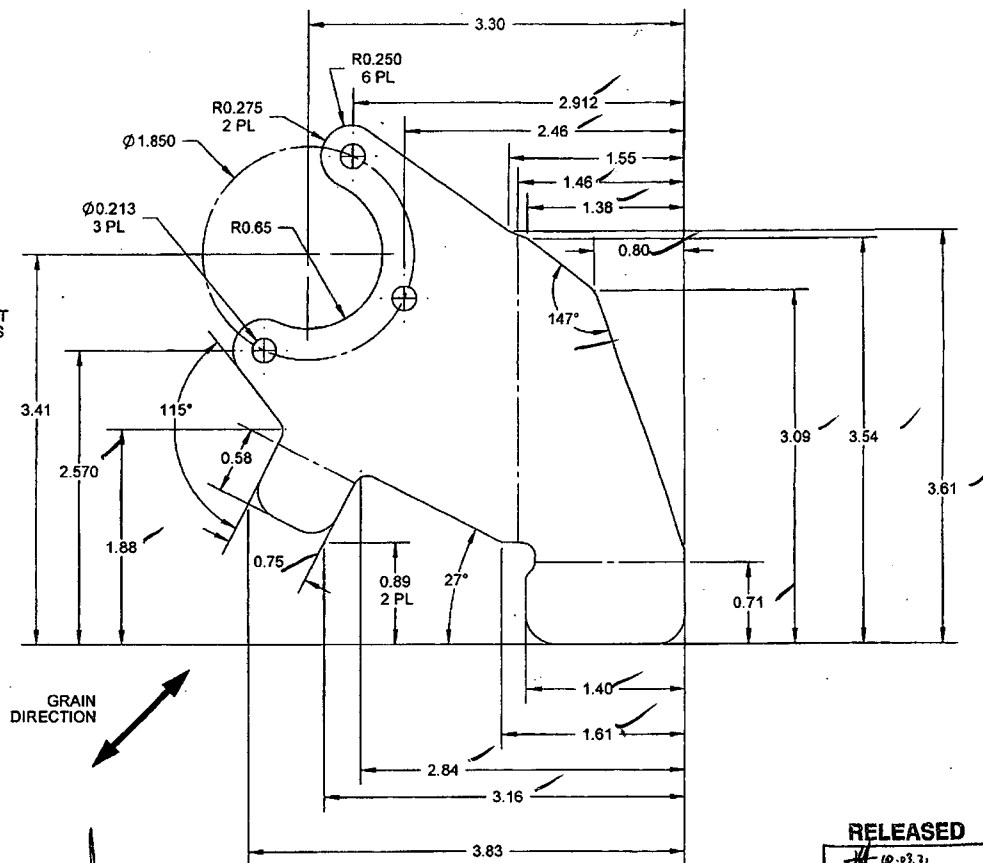
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Measured by: <i>IB</i>	Audited by: <i>[Signature]</i>	Prototype Approval:
Date: <i>10-11-11</i>	Date: <i>10-11-15</i>	Date:

H:\FORMS\Quality Assurance\approved QA\FAI revD



D212-725-1-195 BRACKET
(MAKE FROM D212-725-1-195F)



GRAIN
DIRECTION

RELEASED

10-03-71

D212-725-1-195F FLAT PATTERN
SCALE 2X

NOTES:

- 1) MATERIAL: 2024-T3 ALUMINUM SHEET 0.025 THICK
PER QQ-A-250/4 OR AMS-QQ-A-250/4
OR AMS 4037
OR ASTM B209
REF. DART SPEC. M2024T3S.025
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: N/A

DESIGN	RF	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	RF	DRAWING NO.	REV. G
MFG. APPR.	RF	D212-725-1	SHEET 65 OF 84
APPROVED	RF	TITLE	SCALE
DE APPR.	RF	212S DETAIL PARTS	NTS
DATE	10.02.12	COPYRIGHT © 2006 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	

wlo
63701

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

L Lacelle

From: Robert Fuentes [rfuentes@dartaero.com]
Sent: October 27, 2010 1:03 PM
To: 'L Lacelle'
Cc: 'H. Siemens'; 'David Shepherd'
Subject: RE:

That be ok Linda, send that part as is, If they have problem I correct that when we release D-4 digits number.

Roberto

From: L Lacelle [mailto:llacelle@dartaero.com]
Sent: Wednesday, October 27, 2010 9:47 AM
To: 'Robert Fuentes'
Cc: 'H. Siemens'; 'David Shepherd'
Subject: FW:

Roberto,
 I have had these cut already to the dxf's you supplied, I can charge Eagle for the scrap parts, or you take them as is...what is your preference?
 Please next time let someone know that the drwg or dxf is changed, we NEVER receive an ECN for the change in these parts, so no one knows about it!

LL

From: David Duval [mailto:dduval@dartaero.com]
Sent: October 27, 2010 11:43 AM
To: Linda Lacelle
Subject:

d212-725-1-123 do we cut it or what

[11:31:31 AM] David Duval: the rad is at 4.00"

[11:34:53 AM] Roberto Fuentes: the new radius is 3.75" from same center as old

[11:36:13 AM] David Duval: send me the new dxf with the new dwg

[11:41:32 AM] Roberto Fuentes: ok, I will send to replace old file that you have.

[11:42:22 AM] David Duval: plus the dxf you sent me is missing the 2 bottom hole .25"

David Duval

Production Engineering Coordinator



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dduval@dartaero.com



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11/15/10